

Work Order ID 72193-1

Wednesday, July 20, 2011 7:48:03 AM



Page 1

Item ID: D3719-041

Revision ID:

Item Name: Wearplate

Start Date: 7/19/2011

Start Qty: 6.00

Required Date: 7/26/2011

Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-07-20 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3719  
Deburr if necessary

Dwg Rev: A

Prog Rev: A 2-

0.00

11/07/21

6

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

11/07/21

6

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

11 07 21 6

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72193

Wednesday, July 20, 2011 7:48:03 AM



Item ID: D3719-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Large Fab

Large Fab

Large Fab

Memo

1-Weld D3009-3 caps as per dwg D3719 12-Weld hard facing as per Dwg  
D3719 1 A/R 2059B Hard Coat rod Batch: M114509

m118196

(2)

11-07-22 JBC/12

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

11

07.25

(2)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

11

07 25

(2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72193

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Item ID: D3719-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

8:40

OVEN TEMPERATURE:

FINISH TIME:

9:10

2.

11-7-25

11-7-25

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2 4 10 11/7/25

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

11/7/25 QSP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3719-041

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 7/19/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/17/25 *[Signature]*

U 4407.25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, July 20, 2011 7:48:09 AM

Page 1

Work Order ID: 72193

Parent Item: D3719-041

Parent Item Name: Wearplate



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD  
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3009-3

Manufactured No

100

Each

29.0000

4

24



Cup

Location

Loc Qty

Loc Code

WA030

29

42377

29

M304S16GA

Purchased

No

130

sf

219.4000

0.565

3.568421



304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

19.4

117275

1.7

117653

17.7

MAT021

200

118217

200



8

11-07-22 JBL  
C/L 11-07-22



8

4.0 JBL 11/07/21



PARTS LIST FOR D3719-041 WEARPLATE:

QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP

2059B HARDCOAT  
(6 PLACES)

0.063  
TO  
0.125

1.00  
PITCH  
(TYP)

3.25  
(TYP)

1.50 (REF)

1.00

1.00

HARDCOAT WELD  
SURFACING (REF)

D3719-1 WEARPLATE

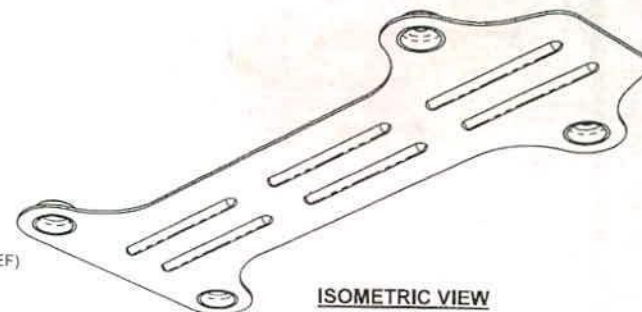
INSTALL D3009-3 (REF) FLUSH  
WITH THIS SURFACE (TYP)

D3009-3 CUP  
(4 PLACES)

(4 PLACES)

1/32

**D3719-041 WEARPLATE**



**ISOMETRIC VIEW**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *72193*

*2110720*

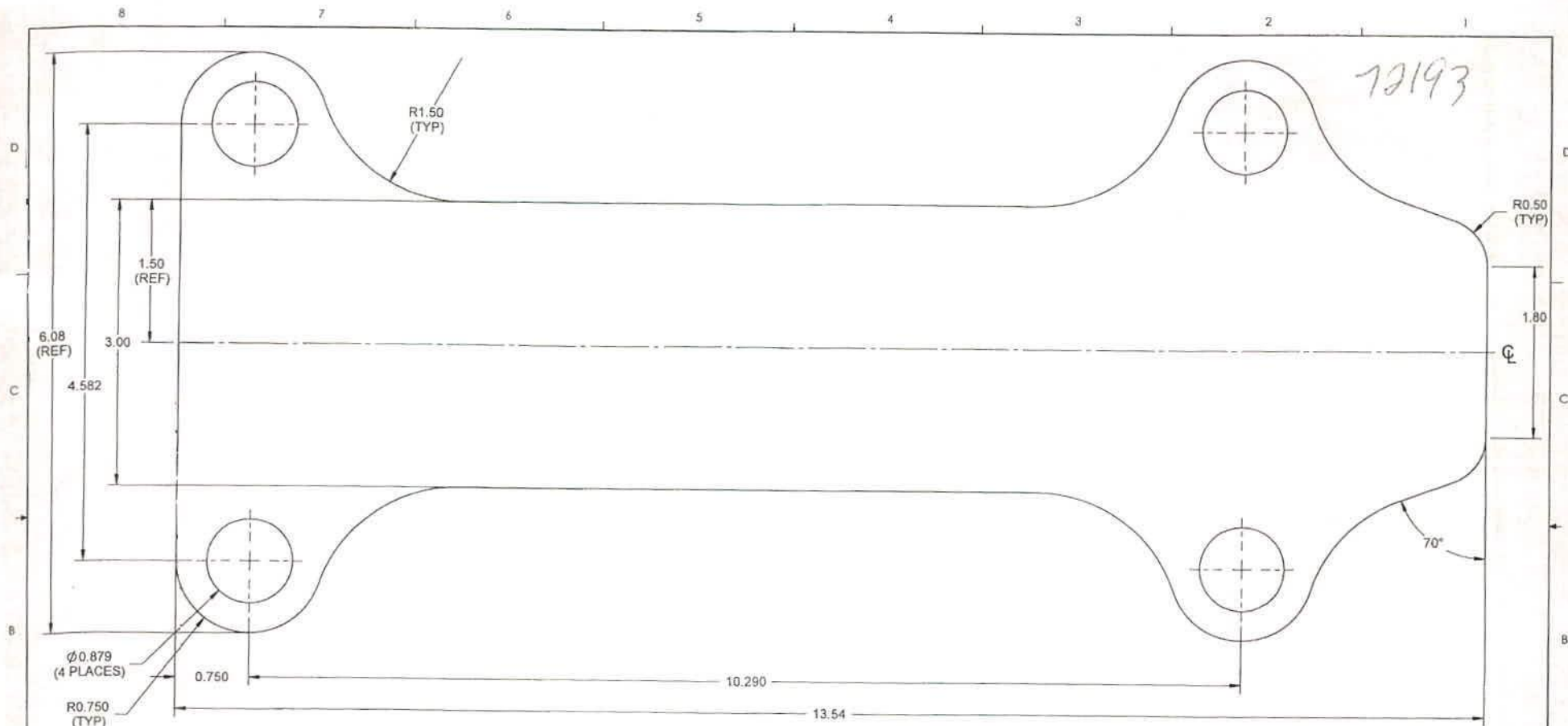
**RELEASED**  
*05-01-07*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEK" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004

A	NEW ISSUE	CP	07.12.12
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3719</b> TITLE <b>WEARPLATE</b> SCALE 1:2 REV. A SHEET 1 OF 2 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			





**D3719-1 WEARPLATE**

**RELEASED**  
07.07.12

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)  
(REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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DE APPR.		WEARPLATE	1:1
DATE	07.12.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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